



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

646.4001

Job Sheet 193140



009449

Part No: 646.4001

Job Qty: 1 pcs

Part Name: AS350 Cable Cutter System



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 4/9/19

Job Tracking No:

Due Date: 4/30/19

Created By: Dara Macdonald

Type: Stock

Description:

Note: DWG REV C1 IPP REV:A 12.10.23 NEW ISSUE DD VERF:JLM IPP REV:B 15.01.08 AS PER DWG REV.B DD VERF:JLM IPP REV:C 16.01.07 AS PER DWG REV.C DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	Packaging 1 - Pick Kit	1 pcs	4/30/19		0.00	0.00	Packaging 1 - 1		
							Packaging 1 - 2		
							Packaging 1 - 3		
							Packaging 1 - 4		
							Packaging 1 - 5		
							Packaging 1 - 6		
							Packaging 1 - 7		
							Packaging 1 - 8		
							Packaging 1 - 9		
							Packaging 1 - 10		
							Packaging 1 - 11		
							Packaging 1 - 12		
							Packaging 1 - 13		
							Packaging 1 - 14		
							Packaging 1 - 15		
							Packaging 1 - 16		
							Packaging 1 - 17		
							Packaging 1 - 18		
							Packaging 1 - 19		
							Packaging 1 - 20		
							Packaging 1 - 21		
							Packaging 1 - 22		
							Packaging 1 - 23		
							Packaging 1 - 24		
							Packaging 1 - 25		
							Packaging 1 - 26		
							Packaging 1 - 27		
							Packaging 1 - 28		
							Packaging 1 - 29		



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CANADA
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Container No: S179353



Part: 646.4001

Job No: 193140

Serial No/Batch: S179353

Revision:

Inspector:

Exp Date: 10/05/2019

Instructions: FAA STC SR02180LA 14/08/07, TC, STC SH09 -

Plex 4/9/19 10:14 AM Dart.Macdonald.Dara

				Packaging 1 - 30	
				Packaging 1 - 31	
				Packaging 1 - 32	
				Packaging 1 - 33	
				Packaging 1 - 34	
				Packaging 1 - 35	
				Packaging 1 - 36	
120	QC 4	1 pcs	4/30/19	0.00 0.00	QC 4 - 28
					QC 4 - 58
					QC 4 - 69
					QC 4 - 9
					QC 4 - 46
130	Packaging 3-1 - Stock - B4B	1 pcs	4/30/19	0.00 0.00	Packaging 3 - 1 - B4B
					Packaging 3 - 2 - B4B
					Packaging 3 - 3 - B4B
					Packaging 3 - 4 - B4B
					Packaging 3 - 5 - B4B
					Packaging 3 - 6 - B4B
					Packaging 3 - 7 - B4B
					Packaging 3 - 8 - B4B
					Packaging 3 - 9 - B4B
					Packaging 3 - 10 - B4B
					Packaging 3 - 11 - B4B
					Packaging 3 - 12 - B4B
					Packaging 3 - 13 - B4B
					Packaging 3 - 14 - B4B
					Packaging 3 - 15 - B4B
					Packaging 3 - 16 - B4B
					Packaging 3 - 17 - B4B
					Packaging 3 - 18 - B4B
					Packaging 3 - 19 - B4B
					Packaging 3 - 20 - B4B
					Packaging 3 - 21 - B4B
					Packaging 3 - 22 - B4B
					Packaging 3 - 23 - B4B
					Packaging 3 - 24 - B4B
					Packaging 3 - 25 - B4B
					Packaging 3 - 26 - B4B
					Packaging 3 - 27 - B4B
					Packaging 3 - 28 - B4B
					Packaging 3 - 29 - B4B
					Packaging 3 - 30 - B4B
					Packaging 3 - 31 - B4B
					Packaging 3 - 32 - B4B
					Packaging 3 - 33 - B4B
					Packaging 3 - 34 - B4B
					Packaging 3 - 35 - B4B
					Packaging 3 - 36 - B4B
135	DC - 1 - B4B	1 pcs	4/30/19	0.00 0.00	DC - 1 - B4B
					DC - 2 - B4B
140	QC 21 - FG	1 pcs	4/30/19	0.00 0.00	QC 21 - FG - 21
					QC 21 - FG - 70
					QC 21 - FG - 53

DAS

46

9-89

MAY 09 2019

DAS

46

9-89

MAY 09 2019

Fg102

DAS

21

9-89

MAY 09 2019

DAS

21

9-89

MAY 09 2019

Part Op 110 - pick kit

Descriptions: 120 - QC4- 100% Inspect kits for completeness

130 - Identify and pack for shipping as per PPP 646.4001 Location: _____

135 - Document Control - Photocopy bluefile & type labels per PPP 646.4001

140 - QC21- Final Inspection - Work Order Release

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
600.0129	VHB Tape	8 ft (8 ea)	110-Packaging 1 - Pick Kit	5158040
600.0990	Magnabond 6398 Part A Size 112 ml	1 Ea (1 ea)	110-Packaging 1 - Pick Kit	5140436
600.0991	Magnabond 6398 Part B Size 112 ml	1 Ea (1 ea)	110-Packaging 1 - Pick Kit	5140437
600.1012	Sealant PR1425B2 (#654 sem)	1 pcs (1 ea)	110-Packaging 1 - Pick Kit	5157375
600.1013	021200-3M Tape Primer 94 Primer 24216	5 Ea (5 ea)	110-Packaging 1 - Pick Kit	5136734
646.2910	Deflector	1 pcs (1 ea)	110-Packaging 1 - Pick Kit	5154493
646.3001	Lower Cable Cutter Assembly	1 pcs (1 ea)	110-Packaging 1 - Pick Kit	5168545
646.3110	Channel	1 pcs (1 ea)	110-Packaging 1 - Pick Kit	5159342
646.3210	Support	1 pcs (1 ea)	110-Packaging 1 - Pick Kit	5153194
646.3301	Upper Cutter Assembly	1 pcs (1 ea)	110-Packaging 1 - Pick Kit	5166869
646.3510	Strut	1 Ea (1 ea)	110-Packaging 1 - Pick Kit	5127140
646.3511	Strut	1 pcs (1 ea)	110-Packaging 1 - Pick Kit	5127662
646.3610	Filler	1 pcs (1 ea)	110-Packaging 1 - Pick Kit	5131480
646.3710	Doubler	1 pcs (1 ea)	110-Packaging 1 - Pick Kit	5059684
646.3711	Clip	1 pcs (1 ea)	110-Packaging 1 - Pick Kit	5128060
646.3712	Clip	1 pcs (1 ea)	110-Packaging 1 - Pick Kit	5128050
646.3713	Gusset	1 Ea (1 ea)	110-Packaging 1 - Pick Kit	5143783
646.3714	Gusset	1 pcs (1 ea)	110-Packaging 1 - Pick Kit	5145099
646.3715	Strut Doubler	2 pcs (2 ea)	110-Packaging 1 - Pick Kit	5139092
646.3716	Gauge Bracket	1 pcs (1 ea)	110-Packaging 1 - Pick Kit	5063780
646.3717	Doubler	1 pcs (1 ea)	110-Packaging 1 - Pick Kit	5143796
646.3718	Custom Washer	2 pcs (2 ea)	110-Packaging 1 - Pick Kit	5145123
646.3719	Doubler	2 pcs (2 ea)	110-Packaging 1 - Pick Kit	5169110
646.3810	Bracket	2 pcs (2 ea)	110-Packaging 1 - Pick Kit	5150081
646.3811	Radius Block	1 pcs (1 ea)	110-Packaging 1 - Pick Kit	5169576
646.3812	Gusset Bracket	2 pcs (2 ea)	110-Packaging 1 - Pick Kit	5150415
646.3813	AS350 Strut Bracket	1 pcs (1 ea)	110-Packaging 1 - Pick Kit	5131319
646.3910	Shim	4 pcs (4 ea)	110-Packaging 1 - Pick Kit	5146178
646.3911	Shim	1 pcs (1 ea)	110-Packaging 1 - Pick Kit	5133609
646.3912	Shim	4 pcs (4 ea)	110-Packaging 1 - Pick Kit	5165750
646.3913	Shim	1 pcs (1 ea)	110-Packaging 1 - Pick Kit	5041498
646.9410	Shim	1 pcs (1 ea)	110-Packaging 1 - Pick Kit	5056898
647.0112	Strut Bracket	2 pcs (2 ea)	110-Packaging 1 - Pick Kit	5133711
647.7703	Strut Assembly	2 pcs (2 ea)	110-Packaging 1 - Pick Kit	5162563
650.9201	Eyelet Bracket Assembly	2 Ea (2 ea)	110-Packaging 1 - Pick Kit	5145508
AN3-11A	Bolt	10 Ea (10 ea)	110-Packaging 1 - Pick Kit	5157480
AN3-12A	Bolt	2 Ea (2 ea)	110-Packaging 1 - Pick Kit	5133167
AN3-13A	Bolt	1 Ea (1 ea)	110-Packaging 1 - Pick Kit	5098032
AN3-3A	Bolt	4 Ea (4 ea)	110-Packaging 1 - Pick Kit	5167257
AN3-4A	Bolt	10 Ea (10 ea)	110-Packaging 1 - Pick Kit	5149178
AN3-5A	Bolt	2 Ea (2 ea)	110-Packaging 1 - Pick Kit	5149158
AN3-6A	Bolt	2 Ea (2 ea)	110-Packaging 1 - Pick Kit	5149149
AN316C4R	Nut, Jam	2 Ea (2 ea)	110-Packaging 1 - Pick Kit	5133132
AN44-5A	Eyebolt	2 Ea (2 ea)	110-Packaging 1 - Pick Kit	5131191
AN4C7A	Bolt	2 Ea (2 ea)	110-Packaging 1 - Pick Kit	5071343
AN665-34R	Clevis	2 Ea (2 ea)	110-Packaging 1 - Pick Kit	5152641
CCR264SS3-02	Cherry Rivet	36 Ea (36 ea)	110-Packaging 1 - Pick Kit	5156969
CR3213-5-3	Cherry Rivet	14 Ea (14 ea)	110-Packaging 1 - Pick Kit	5133189
MS20426AD5-7	Rivet	2 Ea (2 ea)	110-Packaging 1 - Pick Kit	5140521
MS20470AD5-5.5	Rivet	8 Ea (8 ea)	110-Packaging 1 - Pick Kit	5133922-36
MS20470AD5-6	Rivet	8 Ea (8 ea)	110-Packaging 1 - Pick Kit	5139063
MS20470AD5-7	Rivet	3 Ea (3 ea)	110-Packaging 1 - Pick Kit	5048897
MS21042L08	Nut	2 Ea (2 ea)	110-Packaging 1 - Pick Kit	5123425
MS21042L3	Nut	63 Ea (63 ea)	110-Packaging 1 - Pick Kit	5157802
MS21042L4	Nut	2 Ea (2 ea)	110-Packaging 1 - Pick Kit	5152462
MS21047-3	Nut Plate	18 Ea (18 ea)	110-Packaging 1 - Pick Kit	5166699
MS24693-C278	Screw	5 Ea (5 ea)	110-Packaging 1 - Pick Kit	5152465
MS24694-S51	Screw	5 Ea (5 ea)	110-Packaging 1 - Pick Kit	5157611
MS24694-S54	Screw	2 Ea (2 ea)	110-Packaging 1 - Pick Kit	5133343
MS24694-S55	Screw	3 Ea (3 ea)	110-Packaging 1 - Pick Kit	5152667
MS27039-08-13	Screw	2 Ea (2 ea)	110-Packaging 1 - Pick Kit	5173065
				5123937

-Exp 11/19
Exp 9/19

5169112x1

x1

MS27039-1-10	Screw	2 Ea (2 ea)	110-Packaging 1 - Pick Kit	5148665
MS27039-1-12	Screw	6 Ea (6 ea)	110-Packaging 1 - Pick Kit	5124664415148662
MS27039-1-16	Screw	24 Ea (24 ea)	110-Packaging 1 - Pick Kit	5140520
MS27039-1-19	Screw	22 Ea (22 ea)	110-Packaging 1 - Pick Kit	5155664
MS27039-1-20	Screw	2 Ea (2 ea)	110-Packaging 1 - Pick Kit	5074554
MS27039-1-21	Screw	4 Ea (4 ea)	110-Packaging 1 - Pick Kit	5167939
NAS1149F0332P	Washer	144 Ea (144 ea)	110-Packaging 1 - Pick Kit	5150462
NAS1149F0363P	Washer	2 Ea (2 ea)	110-Packaging 1 - Pick Kit	5075330
NAS1149F0432P	Washer	4 Ea (4 ea)	110-Packaging 1 - Pick Kit	5167213
NAS1149FN832P	Washer	4 Ea (4 ea)	110-Packaging 1 - Pick Kit	5134702

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
110-Packaging 1 - Pick Kit	600.0129	8	216	0
	600.0990	1	22	0
	600.0991	1	22	0
	600.1012	1	25	0
	600.1013	5	156	0
	646.2910	1	21	0
	646.3001	1	9	0
	646.3110	1	20	0
	646.3210	1	13	0
	646.3301	1	9	0
	646.3510	1	16	0
	646.3511	1	16	0
	646.3610	1	12	0
	646.3710	1	25	0
	646.3711	1	12	0
	646.3712	1	15	0
	646.3713	1	19	0
	646.3714	1	18	0
	646.3715	2	35	0
	646.3716	1	11	0
	646.3717	1	17	0
	646.3718	2	35	0
	646.3719	2	34	0
	646.3810	2	25	0
	646.3811	1	13	0
	646.3812	2	38	0
	646.3813	1	8	0
	646.3910	4	33	0
	646.3911	1	16	0
	646.3912	4	30	0
	646.3913	1	11	0
	646.9410	1	73	0
	647.0112	2	73	0
	647.7703	2	20	0
	650.9201	2	31	0
	AN3-11A	10	333	0
	AN3-12A	2	263	0
	AN3-13A	1	45	0
	AN3-3A	4	307	0
	AN3-4A	10	718	0
	AN3-5A	2	331	0
	AN3-6A	2	383	0
	AN316C4R	2	36	0
	AN44-5A	2	53	0
	AN4C7A	2	107	0
	AN665-34R	2	52	0
	CCR264SS3-02	36	883	0
	CR3213-5-3	14	173	0
	MS20426AD5-7	2	867	0
	MS20470AD5-5.5	8	945	0
	MS20470AD5-6	8	813	0
	MS20470AD5-7	3	70	0
	MS21042L08	2	1,196	0
	MS21042L3	63	3,710	0
	MS21042L4	2	4,172	0
	MS21047-3	18	443	0

MS24693-C278	5	116	0
MS24694-S51	5	202	0
MS24694-S54	2	139	0
MS24694-S55	3	117	0
MS27039-08-13	2	436	0
MS27039-1-10	2	383	0
MS27039-1-12	6	138	0
MS27039-1-16	24	1,156	0
MS27039-1-19	22	731	0
MS27039-1-20	2	66	0
MS27039-1-21	4	107	0
NAS1149F0332P	144	5,603	0
NAS1149F0363P	2	442	0
NAS1149F0432P	4	2,264	0
NAS1149FN832P	4	2,387	0

Part Specifications

Specifications could not be found.

Plex 4/9/19 10:14 AM Dart.Macdonald.Dara

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NOTES:

1. AFTER INSTALLATION, APPLY F/N 54 A/R TO FILL GAPS AND FILLET EDGES.

2. INSTALL F/N 14 WITH F/N 52 & 53.

3. 3M VHB ADHESIVE TAPE .025" THICK X .50" WIDE
VENDOR: MCMASTER-CARR P/N 75935A651.

4. 3M TAPE PRIMER 94, APPLY TO BOTH SURFACES A/R BEFORE TAPE.
VENDOR: R.S. HUGHES P/N D21200-24216.

5. REUSE FASTENERS FROM F/N 1.

6. USE WASHERS A/R AS SHIMS TO OBTAIN BEST FITMENT.

7. AT CUSTOMERS OPTION, INSTALL F/N 65 BY MATCH DRILLING ON TO F/N 1.

8. INSTALL SHIM IF OEM PROVISIONS ARE INSTALLED ON AIRCRAFT, REMOVE SHIM LAYERS TO ACHIEVE CORRECT SIZE. MATCH DRILL HOLES. USE F/N 78 SCREW IN PLACE OF F/N 17 SCREW.

9. NEWER INSTALLATIONS ON AIRCRAFT WITH UPDATED CANOPY MAY REQUIRE DIFFERENT LENGTH SCREWS, USE F/N 62 TO REPLACE F/N 44 & F/N 26 IN PLACE OF F/N 41 WHEN NECESSARY.

UNINCORPORATED ECN(S)

05304

5	5	5	78	601.3875	SCREW	MS24694554
1	1	1	77	646.9410	SHIM	AN3-12A
	4	4	76	601.2764	WASHER	AN3-12A
	2	2	75	601.2973	LOCKNUT	MS27039-0813
	2	2	74	601.2988	SCREW	MS27039-0813
	2	2	73	601.2943	LOCKNUT	MS27042-0
	2	2	72	601.3128	NUT	AN3-12A
	2	2	71	601.3209	LOCKNUT	MS27042-0
	4	4	70	601.2638	WASHER	AN3-12A
	2	2	69	601.2669	BOLT	AN3-12A
	2	2	68	601.3119	CLEVIS	AN3-12A
	2	2	67	601.3121	EYE BOLT	AN3-12A
	2	2	66	650.9201	EYE BRACKET ASSY	AN3-12A
	REF	REF	65	647.5701	GPS MOUNT KIT	AN3-12A
		2	64	601.3151	WASHER	AN3-12A
		2	63	601.2911	SCREW	MS24694553
	24	24	62	601.2637	SCREW	MS27039-1-16
	2	2	61	601.2763	BOLT	AN3-12A
		1	60	646.3913	SHIM	AN3-12A
		4	59	646.3912	SHIM	AN3-12A
		1	58	646.3911	SHIM	AN3-12A
		4	57	646.3910	SHIM	AN3-12A
		5	56	600.1013	PRIMER	AN3-12A
	8 FT	8 FT	55	600.0129	VHB TAPE	AN3-12A
	1	1	54	600.1012	SEALANT	AN3-12A
		1	53	600.0991	MAGNABOND 6396 PART B	AN3-12A
		1	52	600.0990	MAGNABOND 6396 PART A	AN3-12A
	6	10	51	601.2826	BOLT	AN3-12A
			50	646.3814	WIPER BRACKET	AN3-12A
		2	49	601.2910	SCREW	MS27039-1-18
	2		48	601.1365	SCREW	MS27039-1-10
	2		47	646.3719	DOUBLER	AN3-12A
		2	46	646.3718	CUSTOM WASHER	AN3-12A
		1	45	646.3717	DOUBLER	AN3-12A
	22	2	44	601.1948	SCREW	MS27039-1-19
	2	2	43	601.1952	SCREW	MS27039-1-20
	4		42	601.1956	SCREW	MS27039-1-21
4006	4005	4004	4003	4002	4001	4000
REF	REF	REF	REF	REF	REF	REF
FIND #	PART #	DESCRIPTION	MATL	SPEC.		

REV.	DESCRIPTION	DATE	APPROVED
A	INCORPORATED ECN 02791, 0281, 02716 & 02745	03/08/2014	P. BRAVO
B	INCORPORATED ECN 02044, 02079 & 04731	11/04/2014	P. BRAVO
C	INCORPORATED ECN 03098	01/09/2015	P. BRAVO

		2	2	41	601.2829	SCREW	MS24694554	
		2	2	40	601.2831	RIVET	MS20426AD5-7	
		1	1	39	646.3716	GAUGE BRACKET		
		6	6	38	601.1953	SCREW	MS27039-1-12	
	2	2	2	37	646.3715	STRUT DOUBLER		
		2	2	36	601.2824	BOLT	AN3-5A	
12	36		36	35	601.2277	RIVET	CCR06455-3-02	
6	18		18	34	600.0795	NUTPLATE	MS27047-3	
3	3		3	33	601.2565	RIVET	MS20426AD5-7	
1	1		1	32	646.3813	STRUT BRACKET		
4	4		4	31	601.2822	BOLT	AN3-3A	
2	2		2	30	646.3812	GUSSET BRACKET		
8	8		8	29	601.2564	RIVET	MS20426AD5-6	
1	1		1	28	645.3714	GUSSET		
	1	1	1	27	646.3610	FILLER		
	3	3	3	26	601.2830	SCREW	MS24694555	
	2	2	2	25	601.2825	BOLT	AN3-6A	
	1	1	1	24	646.3811	RADIUS BLOCK		
	1	1	1	23	646.3712	CLIP		
	1	1	1	22	646.3711	CLIP		
8	8		8	21	601.2832	RIVET	MS20426AD5-5	
14	14		14	20	601.2020	RIVET	CP3213-5-3	
4	6	4	6	19	601.2823	BOLT	AN3-4A	
	1	1	1	18	601.2827	BOLT	AN3-13A	
	5	5	5	17	601.2912	SCREW	MS24694551	
1	1	1	1	16	646.3713	GUSSET		
1	1	1	1	15	646.3210	SUPPORT		
	1	1	1	14	646.3710	DOUBLER		
	1	1	1	13	646.3110	CHANNEL		
14	10	8	53	6	61	601.1624	LOCKNUT	MS27042-3
16	32	18	120	16	144	601.1607	WASHER	MS11487032P
			1	10	646.3410	LH WIPER DEFLECTOR		
			1	9	646.3411	RH WIPER DEFLECTOR		
		2	2	8	647.7703	STRUT ASSY		
		2	2	7	647.0112	STRUT BRACKET		
	1	1	1	6	646.3511	STRUT		
	1	1	1	5	646.3510	STRUT		
2	2		2	4	646.3810	BRACKET		
		1	1	3	646.2910	DEFLECTOR		
	1	1	1	2	646.3001	LOWER CUTTER ASSY		
		1	1	1	646.3301	UPPER CUTTER ASSY		
X					646.4006	LOWER CUTTER FIXED PROVISIONS		
	X				646.4005	LOWER CUTTER REMOVABLE PROVISIONS		
		X			646.4004	FIXED PROVISIONS KIT		
			X		646.4003	CABLE CUTTERS KIT WITHOUT FIBER PROVISIONS		
			X		646.4002	AS350 WIPER DEFLECTOR KIT		
				X	646.4001	AS350 CABLE CUTTERS KIT		
4006	4005	4004	4003	4002	4001	DESCRIPTION	MATL	SPEC.

QTY	DESCRIPTION	PARTS LIST
NEXT ASSY (S)	ORIGINAL DATE: 08-27-06 DRAWN BY: J. BRAVO CHECKED BY: J. BRAVO DRAWING APPROVAL: J. BRAVO CONTRACT NO:	3030 ENTERPRISE CT., SUITE A VISTA, CA 92081 (760) 724-5300 AS350 CABLE CUTTERS KIT
UNITED STATES GOVERNMENT SPECIFICATIONS ARE INCORPORATED BY REFERENCE TO THE FOLLOWING STANDARDS:	SIZE: 1/8" SCALE: NONE SHEET: 1 OF 5	REV: C DATE: 07/26/16 ENG: NO. 646.4000